

Date: Wednesday, 3/8/2006 10:38:29 AM
 User: Kim Johnston

Process Sheet

| | | | |
|------------------------------------|-------------------------------------|---------------------------|-------------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | INLET VALVE SHAFT |
| Job Number : | 26122 | | |
| Estimate Number : | 12250 | | |
| P.O. Number : | N/A | Part Number : | D34743 |
| This Issue : | 3/8/2006 | S.O. No. : | N/A |
| Prsht Rev. : | NC | Drawing Number : | D3474 REV.A |
| First Issue : | N/A | Project Number : | N/A |
| Previous Run : | N/A | Drawing Revision : | A |
| | Type : | Material : | N/A |
| | MACHINED PARTS | Due Date : | 3/31/2006 |
| Written By : | <i>See comment below</i> | | Qty: 10 |
| Checked & Approved By : | <i>06.03.08</i> | | Um: Each |
| Comment : | est rev. A 06.02.07 New issue EC | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-----------------|------------------|
| 1.0 | OUTSIDE SERVICE | OUTSIDE SERVICES |
|-----|-----------------|------------------|

**Comment:** Sub-Contracting OUTSIDE SERVICES

Issue P/O: 00000768

Email or Ship DXF file to vendor

Laser Cut per Dwg D3474 flat pattern D3474-3F

Material release note required

| | | |
|-----|---------|-----|
| 2.0 | D34743F | Arm |
|-----|---------|-----|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 ARM

| | | |
|-----|-------------|-----------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|

**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

| | | |
|-----|-----|-------------------|
| 4.0 | QC6 | DIMENSIONAL CHECK |
|-----|-----|-------------------|

**Comment:** DIMENSIONAL CHECK

| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 06/03/30
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:38:30 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INLET VALVE SHAFT

Job Number: 26122

Part Number: D34743

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2603-29 (10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST439

C 2603/29 (10)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 2603/30 (10)

Job Completion



U 260329

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

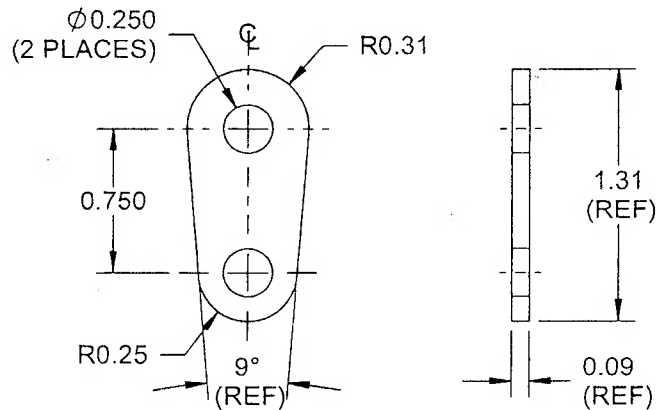
NOTE: Date & initial all entries

PRELIMINARY ISSUE

| | | | |
|------------------|----------|---|------------------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. D3474 | REV. A SHEET 3 OF 4 |
| DATE 03.01.23 | | TITLE INLET VALVE SHAFT | SCALE 1:1 |

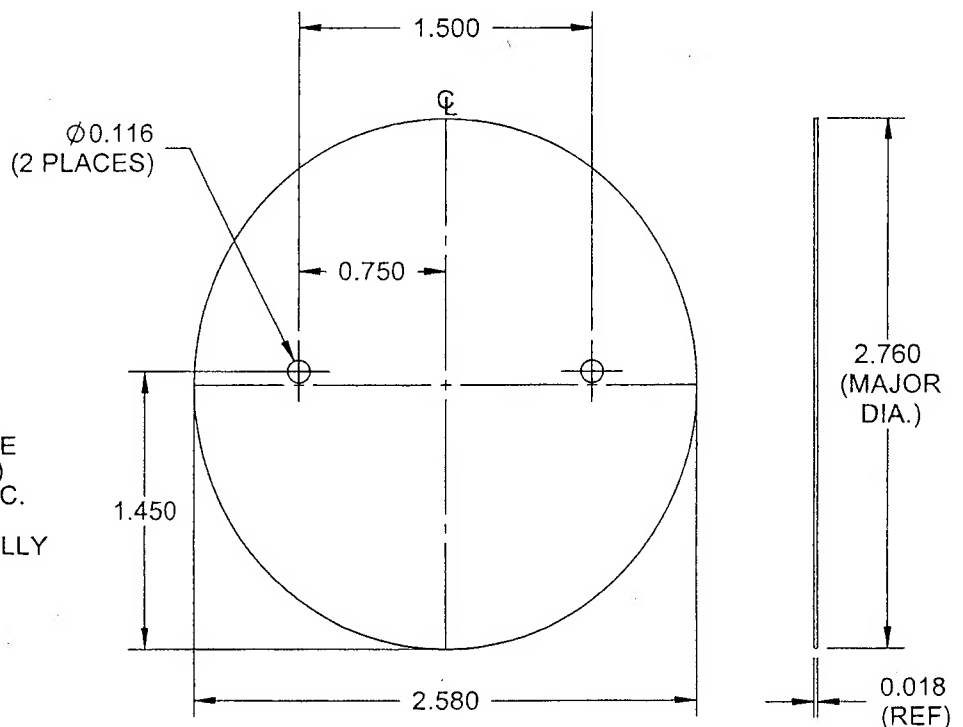
D3474-3 ARM FLAT PATTERN

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 13 GAUGE SS (0.090 THICK) (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE.



D3474-5 PLATE VALVE FLAT PATTERN

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) FINISH: ELECTRO CHEMICALLY POLISHED.



NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

FAX 1 847 585 2500

CORUS ALUMINIUM

Corus Aluminium Walzprodukte G. m. b. H.
 Weg 100331 · D-58033 Koblenz



INSPECTION CERTIFICATE (EN 10204/3.1) / TEST REPORT / APPROVED CERTIFICATE

NO.: 0879231 SERIAL-NO.: PAGE: 2 / 03
 PURCHASER: CORUS ALUMINIUM ROLLED ORDER NO. PURCH.: US-AIRCR. DEPOT-PRO
 PRODUCTS USA-A DIVIS ORDER NO. MAN.: 83415
 SCHAUMBURG, IL 60173 SPEC.: AMS4041+B209+GQ2S0/5
 CUSTOMER PART NO.:
 ITEM: 01 LOT: 102973 ALLOY/TEMPER: 2024 T3 ALCLAD 1230 PRODUCT: PLA
 QUANTITY: 344 DIMENSIONS: 0.040 x 48.00 x 144.00 INS

Other tests:

Dimensional check: OK
 Surface control: OK

Normative references:

BESTELLNORM/SPECIFICATION/NORME
 AMS 4041P+ASTM B 209-04+AMS-QQ-A-250/5A SEP1998

Bend test:

L-direction

LT-direction OK

ST-direction

1 847 585 2500

CORUS ALUMINIUM

Corus Aluminium Walzprodukte G.
Postfach 100331 · D-56033 Koblenz



corus

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PURCHASER: CORUS ALUMINIUM ROLLED ORDER NO. PURCH.: US-AIRCR.DEPOT-PRO
PRODUCTS USA-A DIVIS ORDER NO. MAN.: 83415
SCHAUMBURG, IL 60173 SPEC.: AMS4041+B209+Q2250/5
CUSTOMER PART NO.:

PAGE: 3 / 03

Remarks:

CERTIFIED THAT THE WHOLE OF THE SUPPLIES DETAILED HEREON HAVE BEEN
INSPECTED, TESTED AND, UNLESS OTHERWISE STATED ABOVE, CONFORM IN ALL
RESPECTS WITH THE REQUIREMENTS OF THE SPECIFICATION, CONTRACT OR ORDER.

Enclosures:

Koblenz, the 25.08.05 SW

G. Mattler
Quality Assurance

Corus Aluminium
Walzprodukte GmbH
Koblenz

MAR-23-2006 04:24 FROM:

TD:6049464153

P.2/3

Corus Aluminium-Walzprodukte G.m.b.H.
Postfach 100331 - D-56033 Koblenz



INSPECTION CERTIFICATE (EN 10204/3.1) / TEST REPORT / APPROVED CERTIFICATE

NO.: 0879231 SERIAL-NO.: PAGE: 1 / 03
PURCHASER: CORUS ALUMINIUM ROLLED ORDER NO. PURCH.: US-AIRCR.DEPOT-PRO
PRODUCTS USA-A DIVIS ORDER NO. MAN.: 83415
SCHAUMBURG, IL 60173 SPEC.: AMS4041+B209+QQ250/5
ITEM: 01 LOT: 102973 CUSTOMER PART NO.:
QUANTITY: 344 ALLOY/TEMPER: 2024 T3 ALCLAD 1230 PRODUCT: PLA
DIMENSIONS: 0.040 X 48.00 X 144.00 INS

RESULTS:

Mechanical properties:

| | Spec. No. | Y.S. | U.T.S. | El. |
|----------|-----------|------|--------|------|
| | | KSI | KSI | % |
| Min. LT: | | 39,0 | 59,0 | 15,0 |
| Max. LT: | | | | |
| | 001 | 40,6 | 59,6 | 17,9 |
| | 002 | 40,6 | 59,8 | 18,7 |
| | 003 | 40,8 | 59,8 | 17,7 |
| | 004 | 40,8 | 59,6 | 18,1 |

Chemical composition: in % , remainder Al

| ALLOY: | ALLOY CORE | ALLOY LINER | ALLOY LINER |
|----------|------------|-------------|-------------|
| CAST-NO. | 2024 | 1230 4 | 1230 4 |
| | 5-05-2914 | 142166-1 | 142166-1 |
| Si | 0,028 | 0,12 | 0,12 |
| Fe | 0,123 | 0,26 | 0,26 |
| Cu | 4,326 | 0,002 | 0,002 |
| Mn | 0,634 | 0,010 | 0,010 |
| Mg | 1,436 | 0,003 | 0,003 |
| Cr | 0,001 | 0,001 | 0,001 |
| Zn | 0,011 | 0,005 | 0,005 |
| Ti | 0,0278 | 0,019 | 0,019 |
| B | 0,0006 | 0,002 | 0,002 |
| Zr | 0,0006 | | |
| Pb | 0,0016 | 0,0011 | 0,0011 |
| Ni | 0,0059 | | |